

Date: Wednesday, 02/04/2008 11:27:14 AM
User: Julie Lecocq








Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI ACCESS HANDLE WELDMENT ASS'Y, LH
Job Number :	38292		
Estimate Number :	10946		
P.O. Number :		Part Number :	D2480011
This Issue :	02/04/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2480 REV A1
First Issue :	//	Project Number :	N/A
Previous Run :	38024	Drawing Revision :	A1
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	09/04/2008
Written By :		Qty:	5
		Um:	Each
Checked & Approved By :	JD 08.04.02		
Comment :	Est. B1 03.01.09 added Powder Coat		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2478	Lower Arm
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Lower Arm Pick: Qty Part number Description Batch 1 D2478 Heli Access Handle <u>B 38146</u> ✓ 08-04-08 SP		
2.0	D2479	Upper Arm
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Upper Arm Pick: Qty Part number Description Batch 1 D2479 Heli Access Handle <u>B 38228</u> ✓ 08-04-08 SP		
3.0	D2481	Lower Mount Plate
 		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Lower Mount Plate Pick: Qty Part number Description Batch 2 D2481 Mounting Plate <u>B 38147</u> ✓ 08-04-08 SP		
4.0	D2482	Upper Mount Plate
 		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Upper Mount Plate Pick: Qty Part number Description Batch 1 D2482 Mounting Plate <u>B 14648</u> ✓ → 2x <u>B 23504</u> → 3x 08-04-08 SP		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 38292

Part Number: D2480011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

M106762

5X

SP 08-04-07

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-07 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/04/07 (SLH)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107550

BR 08-04-07

(5) LH

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SLH
M. 08/04/07

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 38275

PC 8/4/8 (5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



MF 08-04-08

N

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

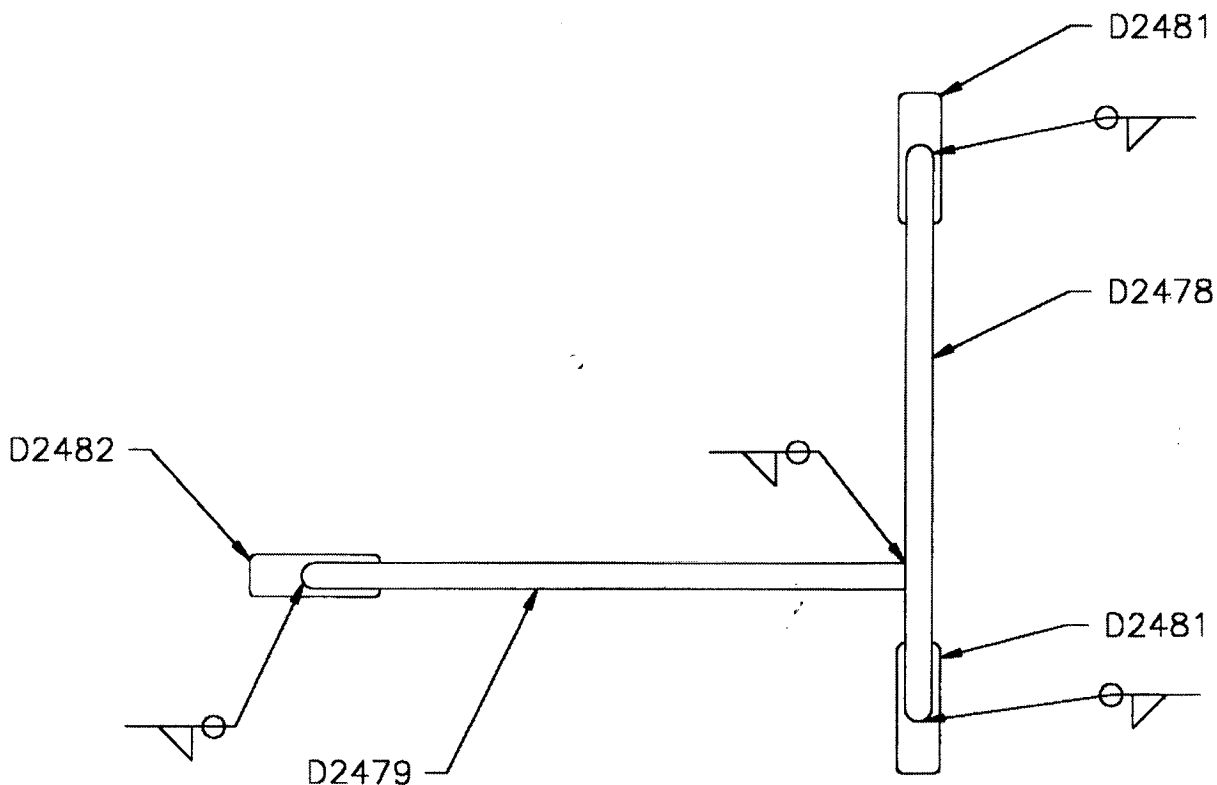
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED BW	APPROVED BW	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
AI	05.06.23	ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

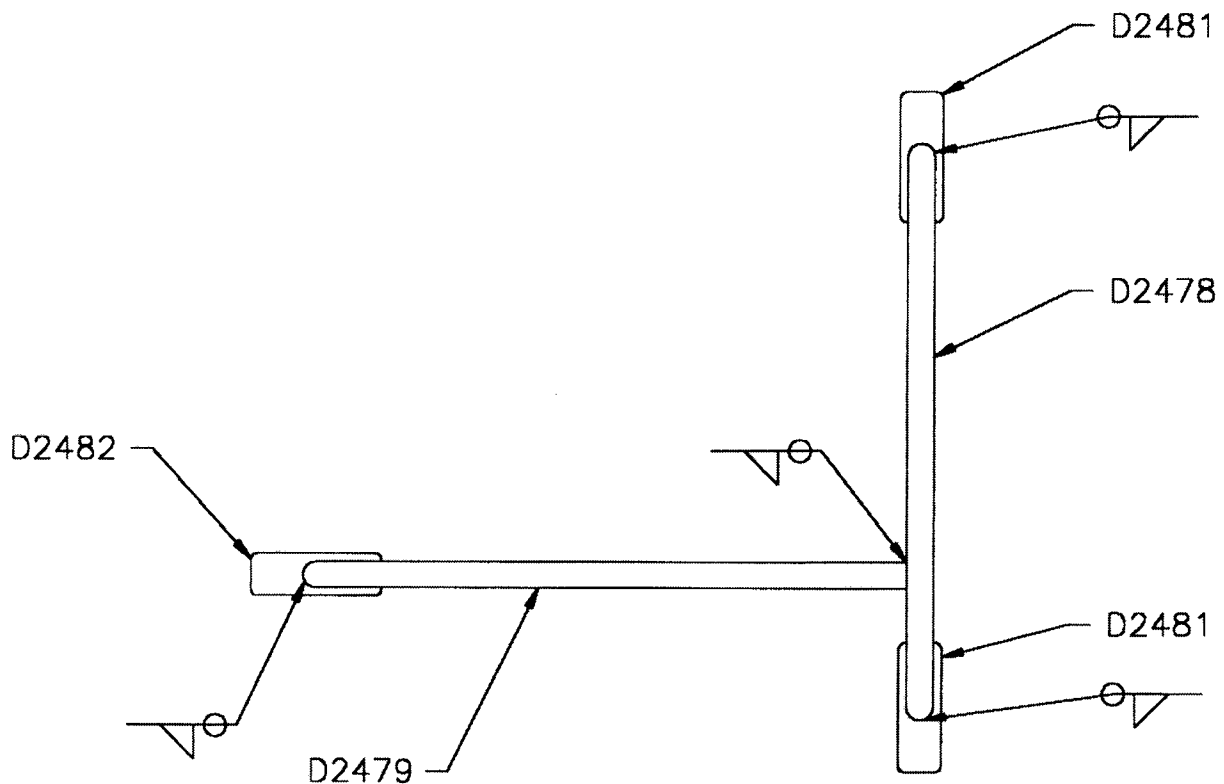
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B WILLIAMS	MIKE M		
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	BW	D2480	SHEET 1 OF 1
DATE	TITLE		SCALE
96:05:14	HANDLE WELDMENT ASSEMBLY		6:1
A1	05.06.23		ADDED POWDER COAT

RELEASED
16/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

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